

Work Order ID 66230

February 8, 2011 8:43:12 AM



Page 1

Item ID: D3537-3

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 2/08/11 Start Qty: 12.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 12.00



Customer:

Reference: }

Approvals: Process Plan: CLDate: 1/10/2008

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3537	Rev C

100 0.00

Waterjet FLOW WATER JET

Waterjet

Memo 0.00

FLOW CNC Waterjet
304 . 063 I-Cut as per Dwg D3537 Dwg Rev: C Prog Rev: C 2-
Deburr if necessaryB 10-2-15(14)

110 0.00

QC QC2- Inspect parts off machine FAI/FAIB

Memo 0.00

B11-2-15

Quality Control

120 0.00

QC QC8- Inspect parts - second check

Memo 0.00

8/10/15(44)

Quality Control

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Start Date: 2/08/11

Start Qty: 12.00



Cust Item ID:

Required Date: 2/22/11

Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

0.00

(14)

Brake NC

Memo

0.00

SB 110216

Brake NC

Deburr if necessary Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3 Form Joggle as per Dwg D3537 on brake using Jig DT8158

140



QC5- Inspect part completeness to step on W/O

0.00

S110216

QC

Quality Control

Memo

0.00

(X4)

Ensure joggle as per dwg D3429

150



Large Fab

0.00

B2 11-5-5 (14)

Large Fab

Memo

0.00

Qty Description Batch A/R 2059B Hardcoat
M117232 Weld hardcoat as per Dwg D3437

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Stop



Start Date: 2/08/11 Start Qty: 12.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

8/11/05/06

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/11/05/06

(14)

180



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

0.00

(14) 8/11/05/06

Memo

START TIME:

3200

12:00

0.00

OVEN TEMPERATURE:

FINISH TIME:

12:30

N1116128

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Item ID: D3537-3

Accept



Setup

Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 2/08/11 Start Qty: 12.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

190



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200



Packaging

Packaging

Identify as per dwg & Stock Location:

FPN

0.00

0.00

(14X) ✓ m-f 11/05/06

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/5/06

MF

11-05-06

Picklist Print

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February 8, 2011 8:43:11 AM

Work Order ID: 66230



Parent Item: D3537-3



Parent Item Name: Wearpad

Start Date: 2/08/11

Required Date: 2/22/11

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No..			100	sf	222.2800	0.149	1.882105	2.1 Bil-2-5		

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT	222.28	
111323	0	
116623	222.28	14623

(14)

DART AEROSPACE LTD	Work Order:	460230
Description: Wearpad	Part Number:	D3537-3
Inspection Dwg: D3537	Rev: C	Page 1 of 1

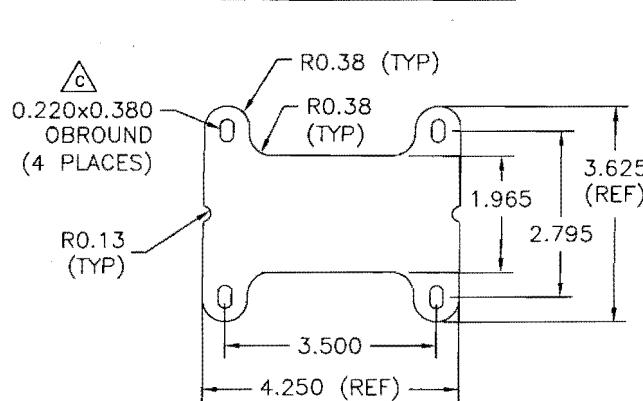
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

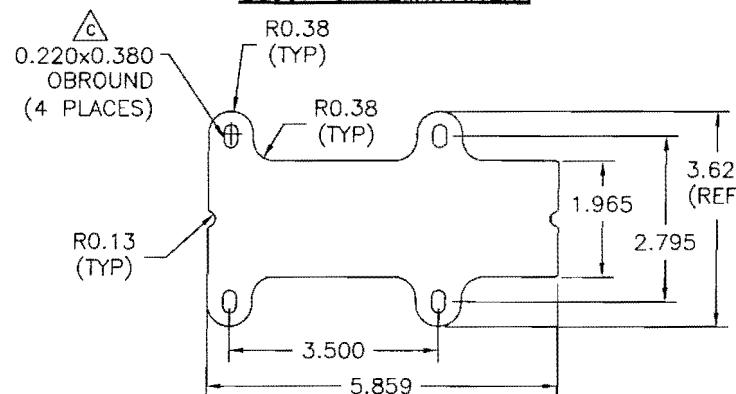
Measured by: <u>B</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: <u>11-2-15</u>	Date: <u>11/2/15</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	E

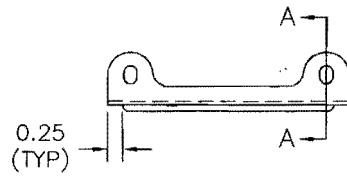
D3537-1F FLAT PATTERN



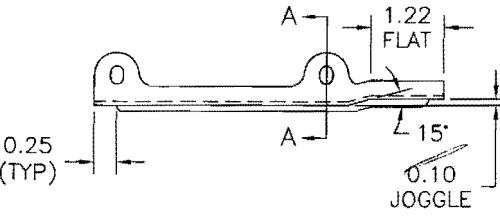
D3537-3F FLAT PATTERN



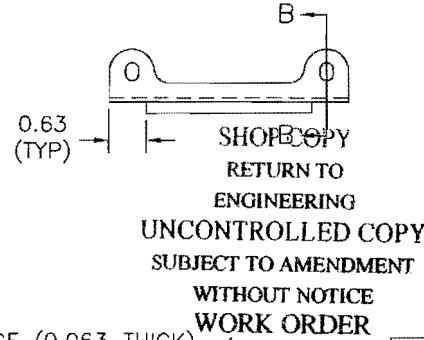
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

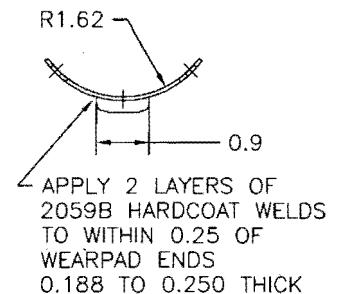
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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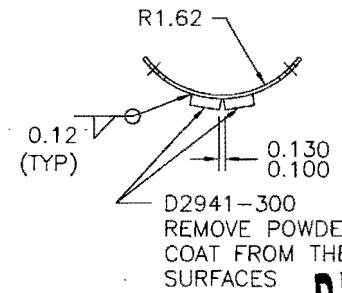
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DART AEROSPACE USA, INC.

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK WA
C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DATE	APPROVED	DRAWING NO. REV. C D3537 SHEET 1 OF 1
07.04.13		TITLE SCALE WEARPAD 1:2

SECTION A-A



SECTION B-B



RELEASED
07.05.08 AM
PC ELN

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)

